

Work Order ID 86632

Friday, July 06, 2012 10:13:57 AM

86632

Page 1

Item ID: D4530-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Latch Roller

Stop ***NS2***

Start Date: 7/5/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: *MLF*

Date: *12-07-08* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4530

A

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FB089 & DWG FOLIO REV: *N/A*

DWG REV: *A*

2-DEBURR AS REQUIRED

12/07/11

4

Ø

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12/07/11

4

Ø

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

12-07-12

4

Ø

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86632***86632***

Page 2

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Latch Roller

Stop ***NS2***

Start Date: 7/5/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location ~~Setup~~ 0.00***130***

115

Packaging

Memo

0.00

X

SP

Packaging

12-7-13

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

CK 12/7/13

Quality Control

MF
12-07-13

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Picklist Print

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Page 1

Work Order ID: 86632

Parent Item: D4530-1

Parent Item Name: Latch Roller

Start Date: 7/5/2012

Required Date: 7/19/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 12-01-06 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R.500 304 SS roundbar .500		Purchased	No			100	f	37.5000	0.0333	0.0701053			

225 12/07/11

Location

Loc Qty

Loc Code

MAT029

37.5

→ 115334

16.56

117890

20.94

225

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

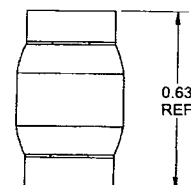
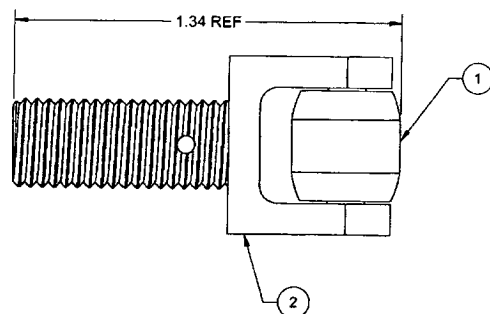
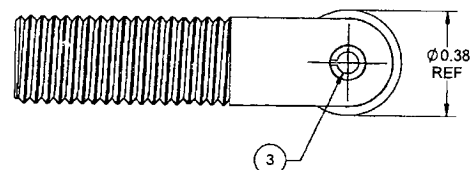
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

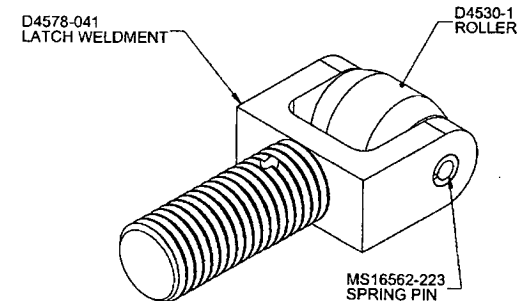
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D4530-041	LATCH ROLLER
1	1	D4530-1	ROLLER
2	1	D4578-041	LATCH WELDMENT
3	1	MS16562-223	SPRING PIN



D4530-041 LATCH ROLLER



86032

RELEASED
2012-03-08

- NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: PER QSI 044 6.6 OR 6.7
 7) WEIGHT: 0.04 lbs

REV.	NEW ISSUE	DESCRIPTION	RP	12.02.24
DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	BY	DATE
DRAWN	RP			
CHECKED	<i>AP</i>	DRAWING NO.	REV. A	
MFG. APPR.	<i>INT</i>	D4530	SHEET 1 OF 2	
APPROVED	<i>INT</i>	TITLE	SCALE	
DE APPR.	<i>INT</i>	LATCH ROLLER	NTS	
DATE	12.02.24	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DEPICTED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

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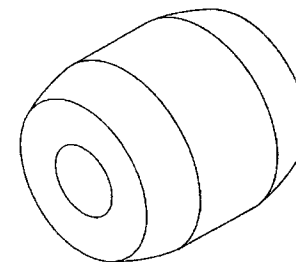
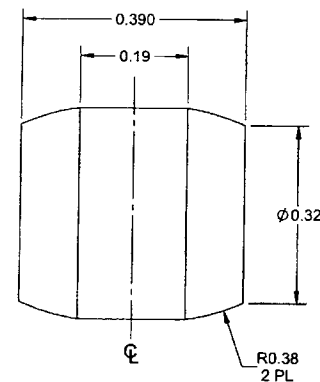
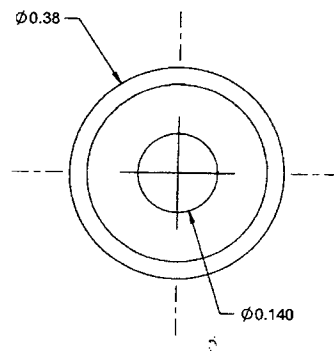
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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86632

D4530-1 ROLLER

RELEASED
2012-03-08

NOTES:

- 1) MATERIAL: AISI 304/316 SS BAR OR AISI 304/316 SS PLATE
PER A276 OR ASTM A240
REF DART SPEC M304B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	<i>A.P.</i>	DRAWING NO. D4530	REV. A
MFG. APPR.	<i>[Signature]</i>	TITLE LATCH ROLLER	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	SCALE NTS	
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
DATE	12.02.24	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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